

Date: Tuesday, 10/03/2009 10:50:41 AM  
User: Julie Dawson

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 46385  
Estimate Number : 10532  
P.O. Number :  
This Issue : 10/03/2009 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : MACHINED PARTS  
Previous Run : 46214

Drawing Name : SADDLE KIT  
Part Number : K10003  
Drawing Number : 634, 635 IIN  
Project Number : N/A  
Drawing Revision : E  
Material :  
Due Date : 31/03/2009

Qty: 8 Um: Each

Written By :  
Checked & Approved By : JULIE DAWSON  
Comment : Est : I 03.01.16 Reformat: Incorporated D205-641-011  
KJ/RF  
Est : J 06-07-25 As per DSI 9344 JLM  
Est : K 06.11.17 Per K10003 Rev C KJ  
Est : L 07.01.12 Document Record for copying bluefile rmv KJ  
Est Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:  
Est N 09.01.27 DSI 9418 rev B EC verified by: DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Handwritten: 09/04/16 Saddle



Comment: DOCUMENT CONTROL

Create White labels only per PPP K10003

CHG 006

Handwritten: rev DSI 9418

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D2570 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total: 192.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	<u>Handwritten: B43750</u>

4.0 D2571 Saddle, Fwd Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	<u>Handwritten: 46432</u>

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 46385

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D2572

Saddle, Fwd In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty

Part Number

Description

Batch

1

D2572

Saddle

46433

SS 09/04/17 (X8)

6.0

D2573

Saddle, Aft Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty

Part Number

Description

Batch

1

D2573

Saddle

B45923 x7 B44206 x1

SS 09/04/17 (X8)

7.0

D2574

Saddle, Aft In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Saddle, Aft, In

Pick:

Qty

Part Number

Description

Batch

1

D2574

Saddle

45924

SS 09/04/17 (X8)

8.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Lug Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3405041

Lug Assembly

9/1/12 54 B46862

SS 09/04/17 (X8)

9.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Lug Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3405043

Lug Assembly

B46863 9/1/12 54

SS 09/04/17 (X8)

10.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Set Screw

Pick:

Qty

Part Number

Description

Batch

4

D2747

Socket Head Set Screw

43855

SS 09/04/17 (X8)



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 46385

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

2

D2876

Spacer

Saddle Spacer

B4236412  
B38662 x 4

88 09/04/17

12.0

D2877



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

2

D2877

Spacer

Set Screw

B43857 x 13  
B39125 x 3

88 09/04/16

13.0

D35331



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Set Screw

Batch:

44644

Bolt

88 09/04/16

14.0

AN46A



Comment: Qty.: 16.0000 Each(s)/Unit Total: 128.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

16

AN4-6A

Bolt

M110399

88 09/04/16

15.0

AN46A



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN4-6A

Bolt

M111176

88 09/04/16

AN4C47A per DS19418

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# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 46385

Part Number: K10003

Job Number:



Description :

Seq. #:

Machine Or Operation:

Bolt

16.0

AN451A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty

8

Part Number  
AN4-51A

Description  
Bolt

Batch

M110328 x48

M109285 x 16

8809/04/16 x8

Bolt

17.0

AN612A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty

8

Part Number  
AN6-12A

Description  
Bolt

Batch

M111193 x 30

M108471 x 34

8809/04/16 x8

Washer

18.0

AN960JD416



Comment: Qty.: 32.0000 Each(s)/Unit Total : 256.0000 Each(s)

Washer

Pick:

Qty

32

Part Number  
AN960JD416

Description  
Washer

Batch

M110363

8809/04/16 x8

Washer

19.0

AN960JD616



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Pick:

Qty

8

Part Number  
AN960JD616

Description  
Washer

Batch

M110704

8809/04/16 x8

Nut

20.0

MS21042L4



Comment: Qty.: 29.0000 Each(s)/Unit Total : 232.0000 Each(s)

Nut

Pick:

Qty

29

Part Number  
MS21042L4

Description  
Nut (or MS21042-4)

Batch

MS21042L4 = M109282

8809/04/16 x8



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 46385

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description:

21.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Tow Ring

batch:

44402 x2 46523 x6

SS 09/04/16 (X)

22.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

batch:

43002

SS 09/04/16 (X)

23.0

MS210434

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nut

batch:

M111177 x11 M1111424 x21

SS 09/04/16 (X)

24.0

D34175

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

batch:

43275 x6 44350 x16

SS 09/04/16 (X)

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

5 09/04/22 (X)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

RK

Rev 2  
9/4/22

(5)

SS

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22

JA

Job Completion



MF 09-04-22



## 5.0 D204-635-011 SKIDTUBE INSTALLATION PARTS LIST

Item	635 -011	635 -041	641 -011	Part Number	Description
	X			D204-635-011	SKIDTUBE INSTALLATION
	1	X		D204-635-041	SKIDTUBE
	1		X	D205-641-011	GROUND HANDLING KIT
1		1		D2590-041	204 SKIDTUBE ASSEMBLY
2A		10		D2594-1	* PLUG
2B		10		D2594-3	* O-RING
3		1		D2855	* AFT CAP
4		2		AN3-5A	* BOLT
5		2		AN960JD10L	* WASHER
6A		1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B		1		D3566-1	* GASKET
7A		1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B		1		D3566-1	* GASKET
8A		1		D3564-7	* WEARSHOE (REPLACES D2577-7)
8B		1		D3566-7	* GASKET
9A		1		D3564-13	* WEARSHOE
9B		1		D3566-13	* GASKET
10		44		AN3C4A	* BOLT (REPLACES AN3-4A)
11		44		AN960C10L	* WASHER (REPLACES AN960JD10L)
12		44		ALS4-1032-130	* INSERT
13		2		ALS4-1032-225	* INSERT
20	1			D2571	SADDLE, FWD OUTSIDE
21	1			D2572	SADDLE, FWD INSIDE
22	1			D2573	SADDLE, AFT OUTSIDE
23	1			D2574	SADDLE, AFT INSIDE
24	8			AN4-51A	BOLT
25	16			D2570	BUSHINGS
26	8			MS21042L4	NUT (OR MS21042-4)
27	8			AN6-12A	BOLT
28	8			AN960JD616	WASHER
29	16			AN4-6A	BOLT
30	32			AN960JD416	WASHER
31	16			MS21042L4	NUT (OR MS21042-4)
32	4			D2747	SET SCREW
33	2			D3533-1	SET SCREW
40	1			D2968-041	TOW RING
41	1			AN970-4	WASHER
43	1			MS21042L4	NUT (OR MS21042-4)
50			1	D2736-1	GHW LUG
51			1	D2736-3	GHW LUG
52			4	AN4-46A	BOLT
53			8	D2570	BUSHING
54			4	MS21042L4	NUT (OR MS21042-4)
60	2			D2876	SADDLE SPACER
61	2			D2877	SADDLE SPACER

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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 WORK ORDER  
 NO. 46385



## 5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D2968-041	TOW RING
41	1	1				AN970-4	WASHER
43	1	1				MS21042L4	NUT (OR MS21042-4)
50					1	D2736-1	GHW LUG
51					1	D2736-3	GHW LUG
52					4	AN4-46A	BOLT
53					8	D2570	BUSHING
54					4	MS21042L4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: E

Date: 08.04.15

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# **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS D204-635 REV. E AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D204-635 REV. 2

REF. CANADIAN STC: SH96-88

REF. FAA STC: SR00563NY

REF. EASA STC: EASA.IM.R.S.01303

## **INSTRUCTIONS:**

- 1) FOR D204-635-011 SKID TUBES @ CHANGE 007 AND SUBSEQUENT, REVISION B OF THIS DSI **SUPERCEDES** REVISION A (DISCARD REVISION A).
- 2) MODIFY THE FOLLOWING:
  - a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
  - b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
  - c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS D204-635 REV. E AND SECTION 32.9 OF THE INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-635 REV. 2 AS FOLLOWS:

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED SEE THE AMENDED PARTS LIST FOR DETAILS.

REFERENCE ONLY

46385

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	08.12.03
CERT. NO.:	SH96-88
ISSUE NO.:	3

B	ADDED SHEET 3. MOVED P/L TO SHEET 2. SHT 2 ADDED GHW LUG TO P/L CHANGE.	AJS	08.10.06
A	NEW ISSUE	AJS	08.07.09
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9418	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	08.10.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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ITEM	635 -011	635 -041	641 -011	PART NUMBER	DESCRIPTION
	X			D204-635-011	SKIDTUBE INSTALLATION
	1	X		D204-635-041	SKIDTUBE
	1		X	D205-641-011	GROUND HANDLING KIT

IS:

40	1			D3407-041	TOW RING ASSEMBLY
41	1			D3456-1	WASHER
43	1			MS21043-4	NUT
44	2			D3417-5	WASHER
50			1	D3405-041	LUG ASSEMBLY
51			1	D3405-043	LUG ASSEMBLY
52			4	AN4C47A	BOLT
53			8	D2570	BUSHING
54			4	MS21043-4	NUT

WAS:

40	1			D2968-041	TOW RING
41	1			AN970-4	WASHER
43	1			MS21042L4	NUT (OR MS21042-4)
50			1	D2736-1	GHW LUG
51			1	D2736-3	GHW LUG
52			4	AN4-46A	BOLT
53			8	D2570	BUSHING
54			4	MS21043-4	NUT

46385

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 08.12.03

CERT. NO.: SH96-88

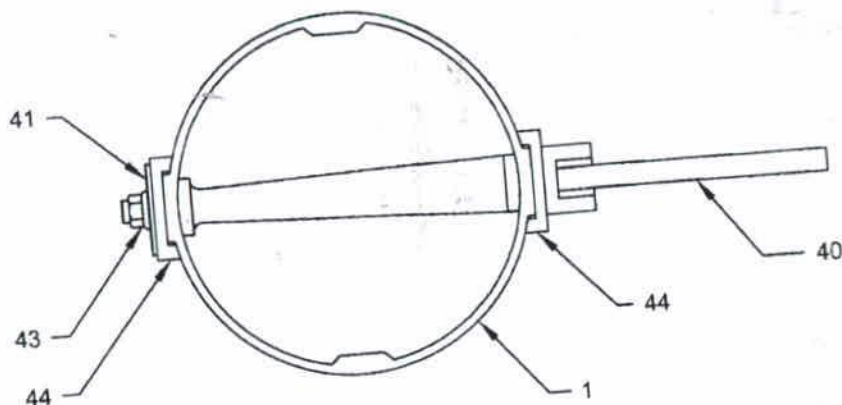
ISSUE NO.: 3

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9418	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	08 10 06	COPYRIGHT © 2006 BY DART AEROSPACE LTD	

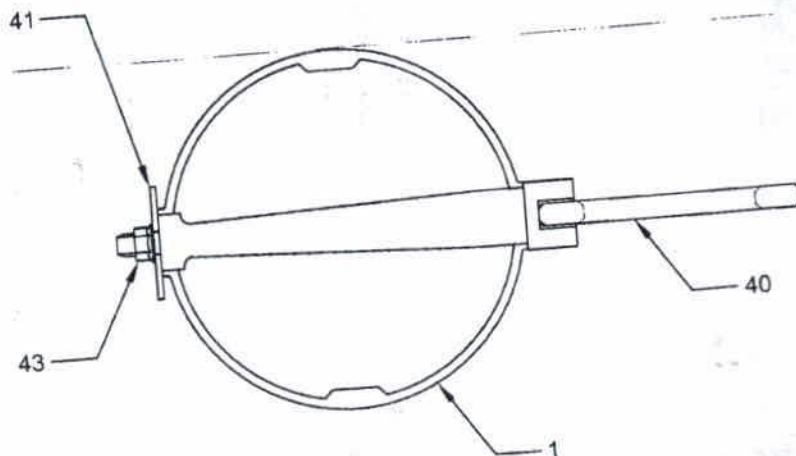
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INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO FIGURE 3, DETAIL C OF D204-635 REV. E AND FIGURE 32-3, DETAIL C OF ICA-D204-635 REV. 2). AMEND SECTION 3.1.3 OF OF D204-635 REV. E AND SECTION 32.5 OF ICA-D204-635 REV. 2 ACCORDINGLY.

**IS:**



**WAS:**



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 08.12.03

CERT. NO.: SH96-88

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED	A	DRAWING NO. DSI 9418
MFG. APPR.	N/A	TITLE SKIDTUBE INSTALLATIONS
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DE APPR.	<i>[Signature]</i>	
DATE	08.10.06	

46385



## 5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
	1	1		X		D205-634-045	SKIDTUBE
					X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C47A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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